

Work Order ID **92121*****92121***

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Tuesday, October 23, 2012 4:12:04 PM

Item ID: PB67-43001-09

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Blade Fold Assembly Weldment

Start Date: 10/23/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLS Date: 12-10-25 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-09	Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001** ensure
no burn thru after welding in tube -235 and -229 only where bushing -265 ***

2 0 12.12.04

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

DAS 09 9-89 12-12-04 ②

2 0 12.12.04 12.12.04

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

DAS 09 9-89 12-12-04 ②

NCR: ☒ Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Adh Date: 12/12/21QA Closed: cl Date: 11

Work Order: <u>92121</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>PB67-43001-09</u>		Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input checked="" type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
NCR No. <u>12-2143</u>					

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	<u>12/12/04</u>	<u>100</u>	<u>X1</u>	Found at inspection that PB67-43001-311 is weld @ 30.250" with a spacing of 1.125". should be @ 30.3125" and have a spacing @ of 30.60" RC not welded at correct location no locator on weldy sig.	<u>12124</u>	Cut off top PB67-43001-311 and see re locate in correct location. Grains weldy flush. and re weld as per OSZ spec A/R <u>122358</u>	<u>12-12-04</u>		<u>12/12/04</u>
Equip/Tooling <input checked="" type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled
		<input checked="" type="checkbox"/> Other <u>Should have a locator on jig for location and distance from weldy parts.</u>

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Item ID: PB67-43001-09 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Blade Fold Assembly Weldment
Start Date: 10/23/2012 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 11/2/2012 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
130	Powdercoat	0.00				2X	✓		mt 12/12/10
	Powder Coating								
140	QC3- Inspect Part Finish	0.00							
140	QC	0.00				2	✓	12-12-10	238
	Quality Control								
150	Identify as per dwg & Stock Location: <u>MM-003</u>	0.00							
150	Packaging	0.00				2	✓		12.12.12
	Packaging								

M18144

12:10

11:40 OVEN TEMPERATURE 320 °F

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Item ID: PB67-43001-09

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Blade Fold Assembly Weldment

Stop ***NS2***Start Date: 10/23/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/12/13

MF
12-12-12

Picklist Print

Tuesday, October 23, 2012 4:12:04 PM

Page 1

Work Order ID: 92121

Parent Item: PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec IPP RevB 10.09.24 per revC
dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-201 Square Tube		Manufactured	No		B92212 = 4	100	Each	0.0000	2	4		12.12.03	
PB67-43001-203 Square Tube		Manufactured	No			100	Each	4.0000	1	2		12.12.03	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST437		4							
				62105		4							
PB67-43001-209 Square Tube		Manufactured	No		B90918 = 2	100	Each	0.0000	1	2		12.12.03	
PB67-43001-210 Square Tube		Manufactured	No			100	Each	2.0000	6	12		12.12.03	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA	B90919 = 10	2							
				85179		2							
PB67-43001-213 Flanged Hook		Manufactured	No			100	Each	1.0000	2	4		12.12.03	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST438	B92216 = 4	1							
				52488		1							
PB67-43001-229 Outer Tube		Manufactured	No			100	Each	1.0000	1	2		12.12.03	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST209a	B90921 = 2	1							
				52487		1							
PB67-43001-235 Outer Tube		Manufactured	No		B90923 = 2	100	Each	0.0000	1	2		12.12.03	

Picklist Print

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Work Order ID: 92121

Parent Item: PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-239

Square Tube

Manufactured No

100

Each

1.0000

1

2

12.11.07

Location

Loc Qty

Loc Code

ST443

B90924 = 2

44986

1

2

PB67-43001-243

Tube Handle Extension

Manufactured No

100

Each

0.0000

1

2

12.12.03

PB67-43001-277

Contoured Male Eye

Manufactured No

100

Each

3.0000

1

2

12.12.03

Location

Loc Qty

Loc Code

ST438

92217 = 2

62110

3

2

4

12.12.03

PB67-43001-311

Restraint

Manufactured No

100

Each

2.0000

2

4

Location

Loc Qty

Loc Code

ST439

B90935 = 4

62112

2

1

2

12.12.03

D3440-9

Tube Detent Clip Base (Supersedes B67-43001-241)

Manufactured No

100

Each

2.0000

1

2

Location

Loc Qty

Loc Code

WA

B92218 = 2

85178

2

1

2

D3440-13

Bracket (Supersedes B67-43001-273)

Manufactured No

100

Each

0.0000

1

2

12.12.03

PB67-43001-223 qty = 14

Batch 47504 = 2 12.12.03

PB67-43001-225 qty = 4

Batch 44988 = 8 12.12.03

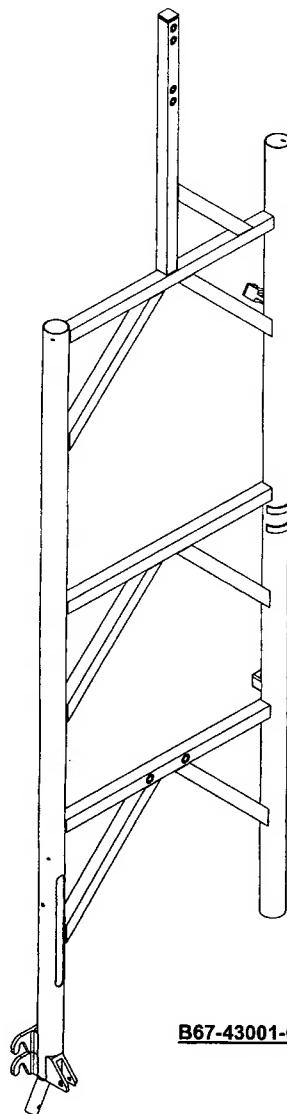
PB67-43001-227 qty = 2

Batch N/A

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Shop Packet Print

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B67-43001-09 AFT BLADE FOLD ASSY WELDMENT

SHOP COPY
R. J. W. CO.
ENGINEERS
UNION
STATION
VICTORIA
B.C.

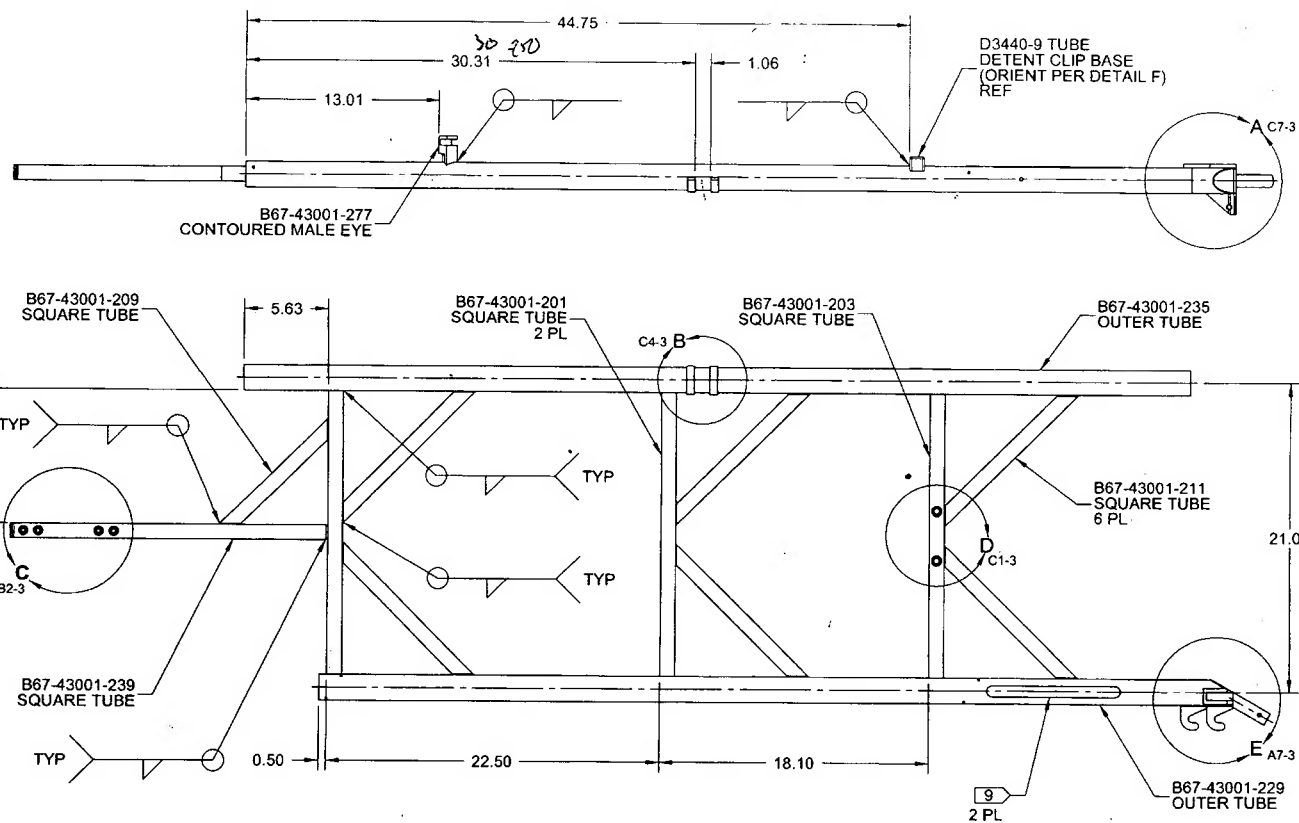
92121 MLS
12-10-25

ITEM	QTY -09	P/N	DESCRIPTION
1	X	B67-43001-09	AFT BLADE FOLD ASSEMBLY WELDMENT
2	2	B67-43001-201	SQUARE TUBE
3	1	B67-43001-203	SQUARE TUBE
4	1	B67-43001-209	SQUARE TUBE
5	6	B67-43001-211	SQUARE TUBE
6	2	B67-43001-213	FLANGED HOOK
7	1	B67-43001-223	SQUARE CAP
8	4	B67-43001-225	BUSHING
9	2	B67-43001-227	BUSHING
10	1	B67-43001-229	OUTER TUBE
11	1	B67-43001-233	OUTER TUBE END CAP
12	1	B67-43001-235	OUTER TUBE
13	1	B67-43001-239	SQUARE TUBE
14	1	B67-43001-243	TUBE HANDLE EXTENSION
15	1	B67-43001-277	CONTOURED MALE EYE
16	2	B67-43001-311	RESTRAINT
17	1	D3440-9	TUBE DETENT CLIP BASE
18	1	D3440-13	BRACKET

RELEASED
R 2010-09-16
MD

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 6 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.05.03
REV.		DESCRIPTION	BY	DATE	
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED		DRAWING NO.	REV. C		
MFG. APPR.		B67-43001-09	SHEET 1 OF 3		
APPROVED		TITLE	SCALE		
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS		
DATE	10.05.03				
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92121



B67-43001-09 AFT BLADE FOLD ASSY WELDMENT

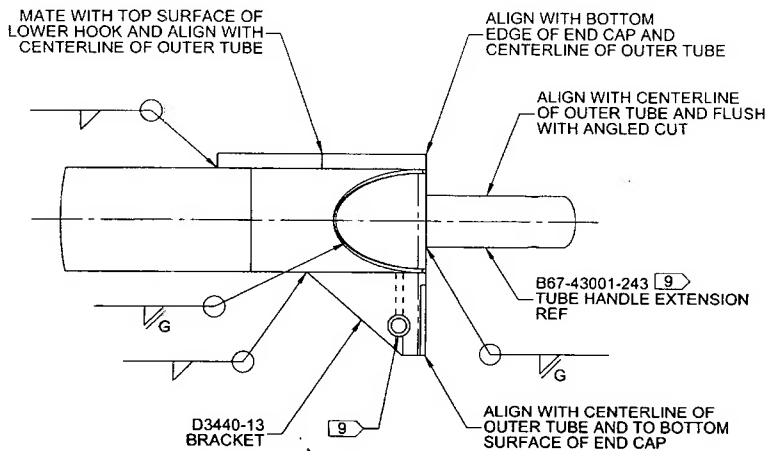
NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.74 lbs
- 8) WELDING: PER QSI 004
- 9) MASKING: ALL OPENINGS AND INDICATED AREAS PRIOR TO POWDER COATING

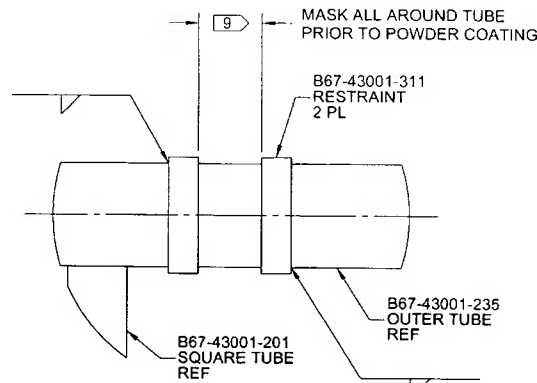
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-09	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
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2010-09-16

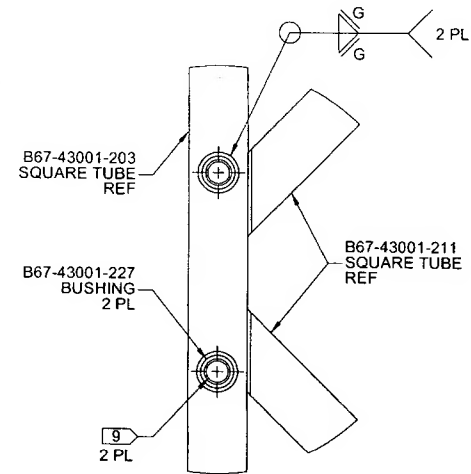
92121



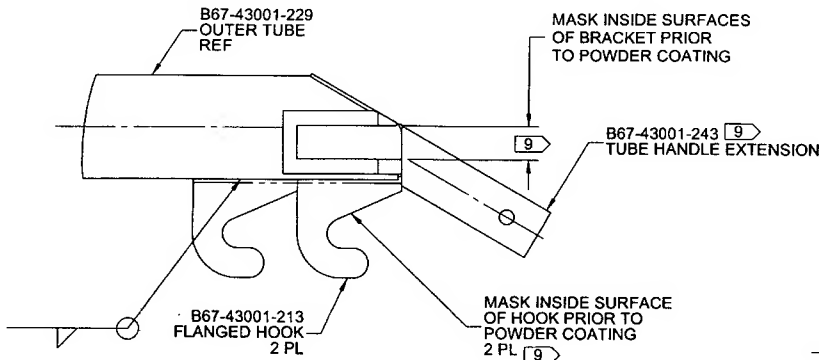
DETAIL A D3-2
SCALE 4X



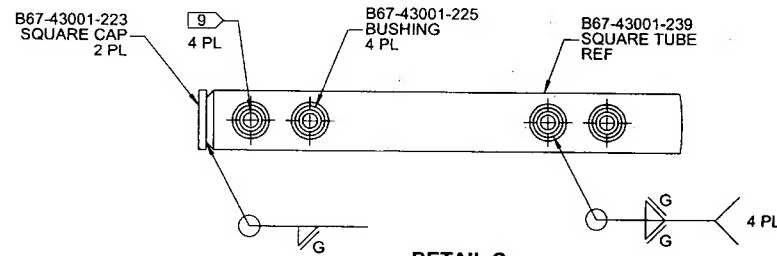
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SCALE 4X



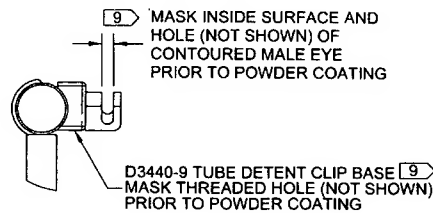
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SCALE 4X



DETAIL E B3-2
SCALE 4X



DETAIL C B8-2
SCALE 4X



DETAIL F C2-2
SCALE 4X

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2010-09-16
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-09	SHEET 3 OF 3
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